










Date: Monday, 06/10/2008 10:44:49 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SEAT FRAME ASSEMBLY								
Job Number : 42441									
Estimate Number : 11122									
P.O. Number :	Part Number : D3016041								
This Issue : 06/10/2008 S.O. No. :	Drawing Number : D3016 REV A								
Prsht Rev. : NC	Project Number : N/A								
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A								
Previous Run : 41977	Material :								
Written By :	Due Date : 30/10/2008 Qty: 1 Um: Each								
Checked & Approved By : <u>JULIE 08.10.06</u>									
Comment : Est. A 01.09.19 New issue EC									
Additional Product									
Job Number: 									
Seq. #:	Machine Or Operation: Description :								
1.0	M4130NT0750W049 4130 RD Tube .750 x.049W								
	 								
Comment: Qty.: 4.5150 f(s)/Unit Total : 4.5150 f(s) 4130 Tube .750 OD x.049W Cut- AISI 4130N tube, Ø3/4" x 0.049" wall Batch: <u>M10498</u> <u>08/11/05</u>									
2.0	M4130NT1000W120 4130 RD Tube 1.00 x .120wall								
	 								
Comment: Qty.: 1.5750 f(s)/Unit Total : 1.5750 f(s) 4130 Tube 1.0"D X 0.120"W batch <u>M11591</u> <u>08/11/05</u>									
3.0	M4130NT0500W049 4130 RD Tube .500 x.049W								
	 								
Comment: Qty.: 4.5150 f(s)/Unit Total : 4.5150 f(s) 4130 Tube .500 OD x.049W Cut- AISI 4130N tube, Ø1/2" x 0.049" wall Batch: <u>M106651</u> <u>08/11/05</u>									
4.0	D301617 Gusset								
	 								
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Gusset Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D3016-17</td> <td>Gusset</td> <td><u>B39641</u></td> </tr> </tbody> </table> <u>08/11/05</u>		Qty	Part Number	Description	Batch	2	D3016-17	Gusset	<u>B39641</u>
Qty	Part Number	Description	Batch						
2	D3016-17	Gusset	<u>B39641</u>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 10:44:49 AM
User: Julie.Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 42441

Part Number: D3016041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	D301613	Bracket
-----	---------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Pick:

Qty	Part Number	Description	Batch
2	D3016-13	Bracket	B34208

M 08/11/05

6.0	D301615	Gusset
-----	---------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gusset

Pick:

Qty	Part Number	Description	Batch
2	D3016-15	Gusset	B25762

M 08/11/05

7.0	D30201	Fitting
-----	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Fitting

Pick:

Qty	Part Number	Description	Batch
4	D3020-1	Fitting	B36713

M 08/11/05

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble and weld as per Dwg D3016 using welding jig DT8597

A/R 4130 Rod Batch: M19317

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

M 08/11/06

9.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

BE 08/11/06 . (C)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 10:44:49 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 42441

Part Number: D3016041

Job Number:



Seq. #: Machine Or Operation: Description:

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/11/06 (R)

11.0

POWDER COATING

POWDER COATING



N/ 10.6 442



(H)

Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

START TIME:

3:40

OVEN TEMPERATURE:

320 °F

FINISH TIME:

4:10

M-A 08/11/06

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-04

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 42416

SS 08/11/06 (R)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/10 (R)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *28941*

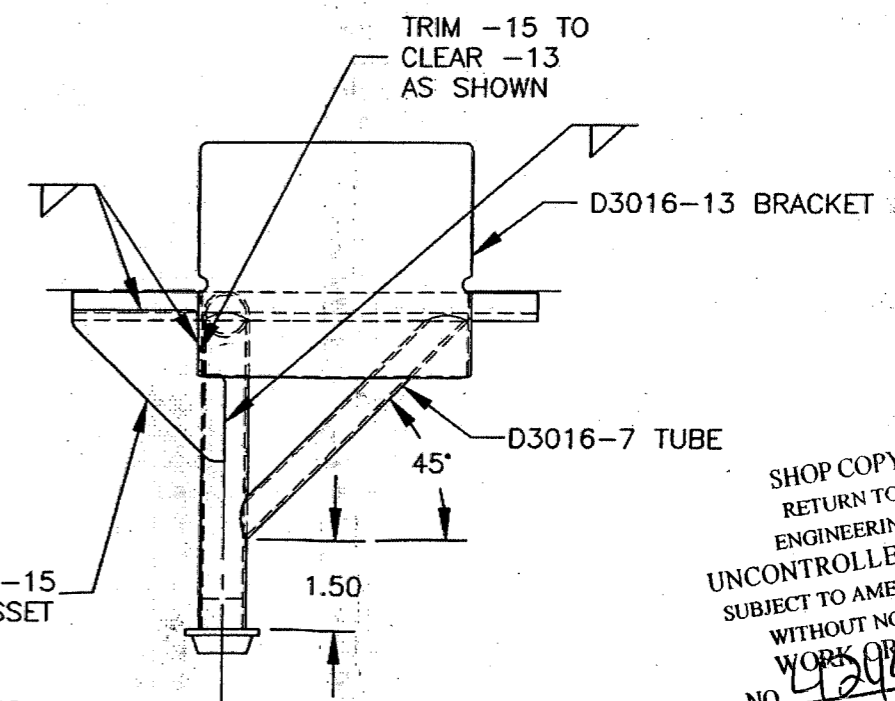
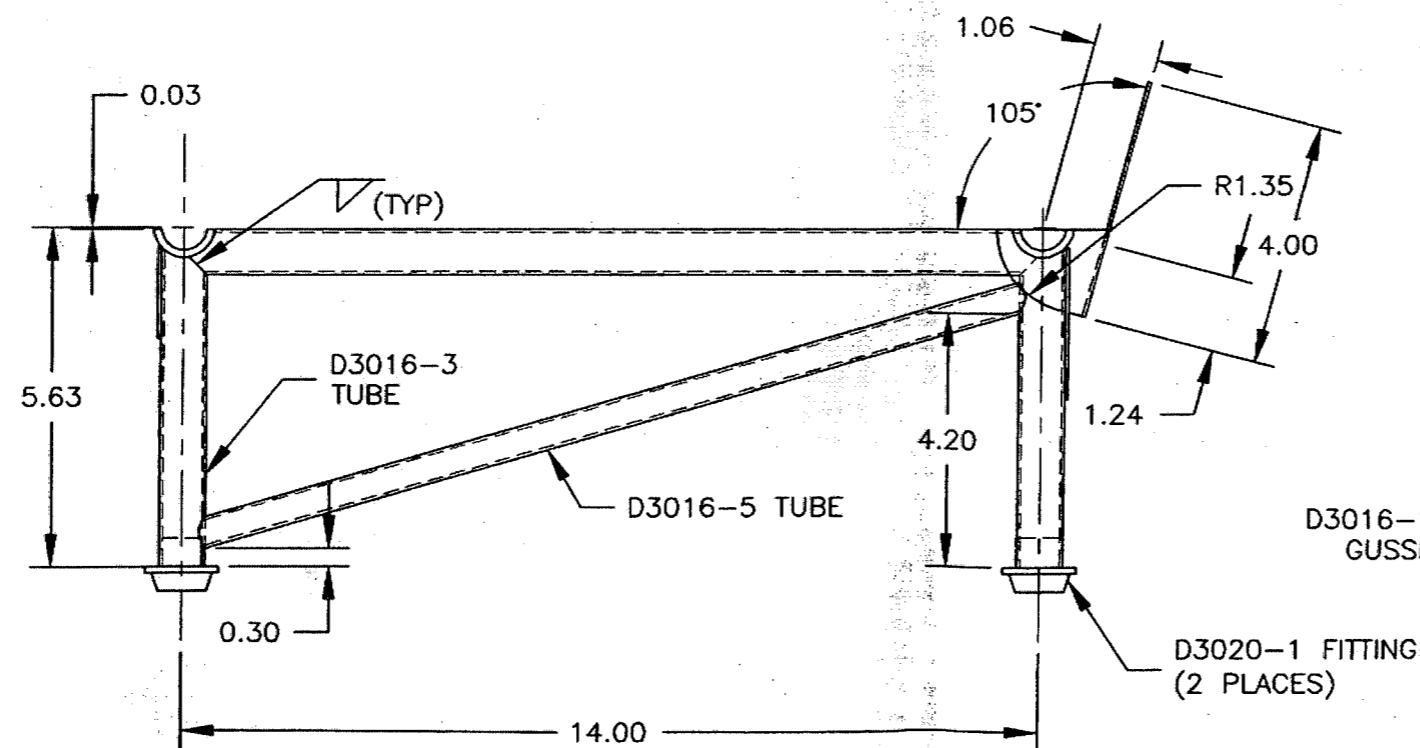
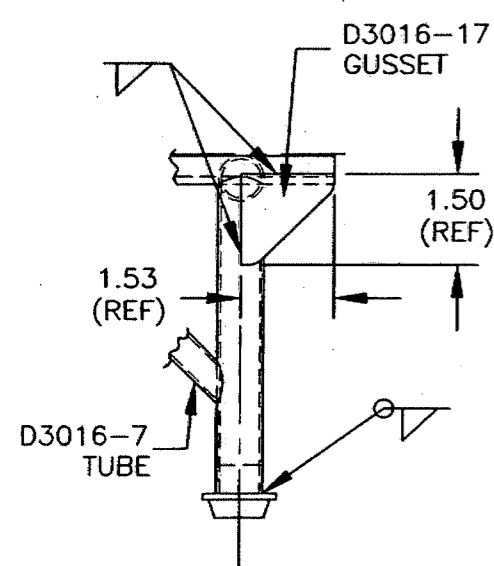
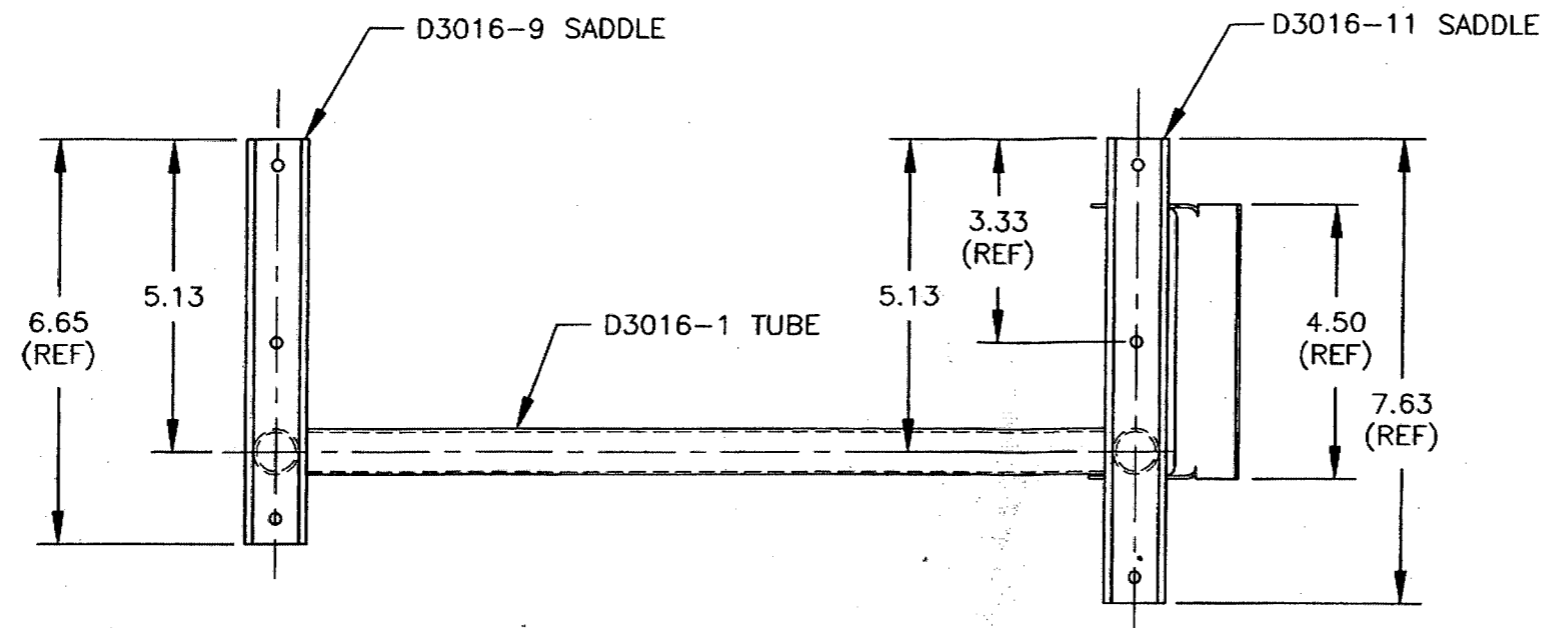
CO: Y
DET

RELEASED
01.05.30 *#*

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

D3016-041 SEAT FRAME ASSEMBLY



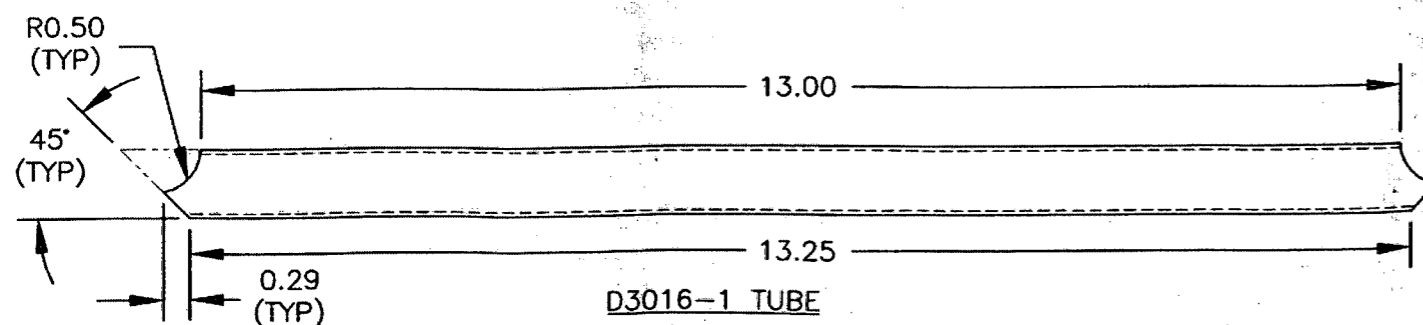
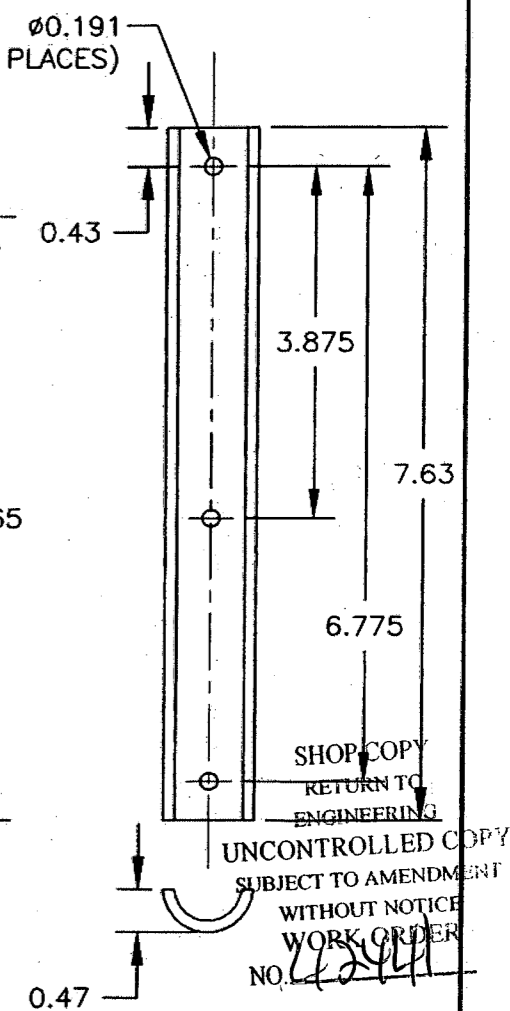
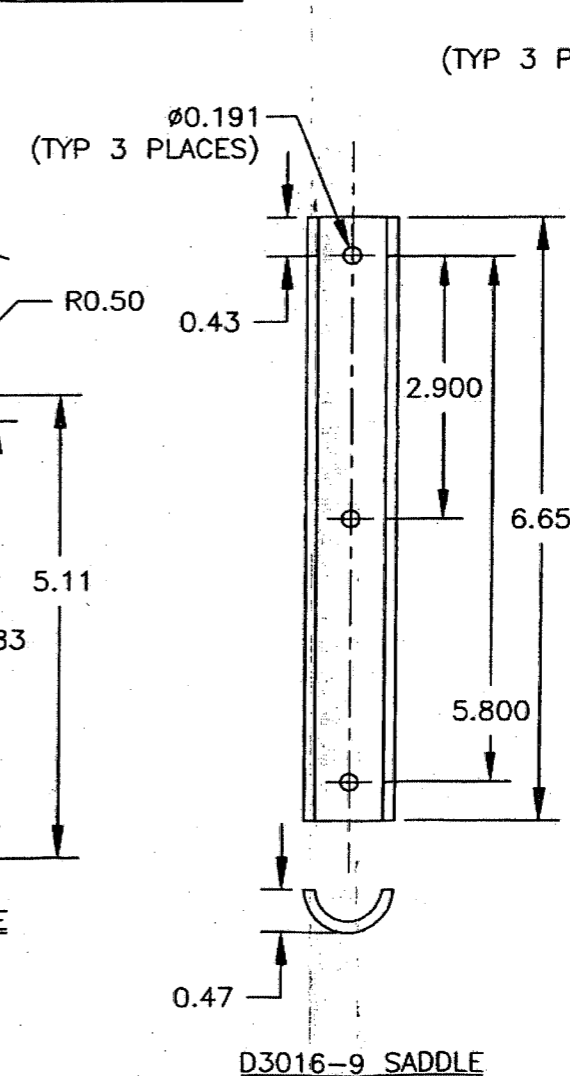
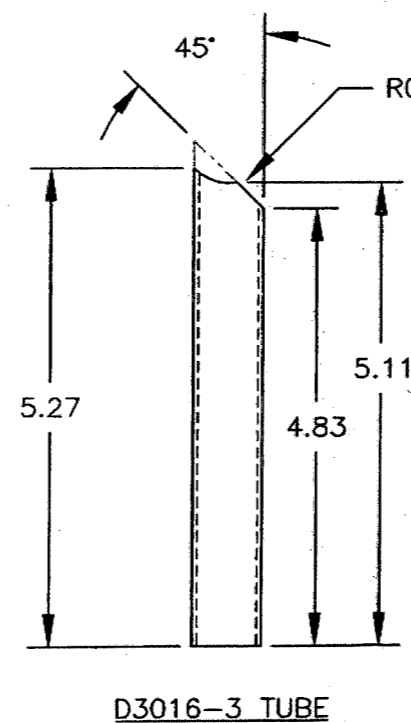
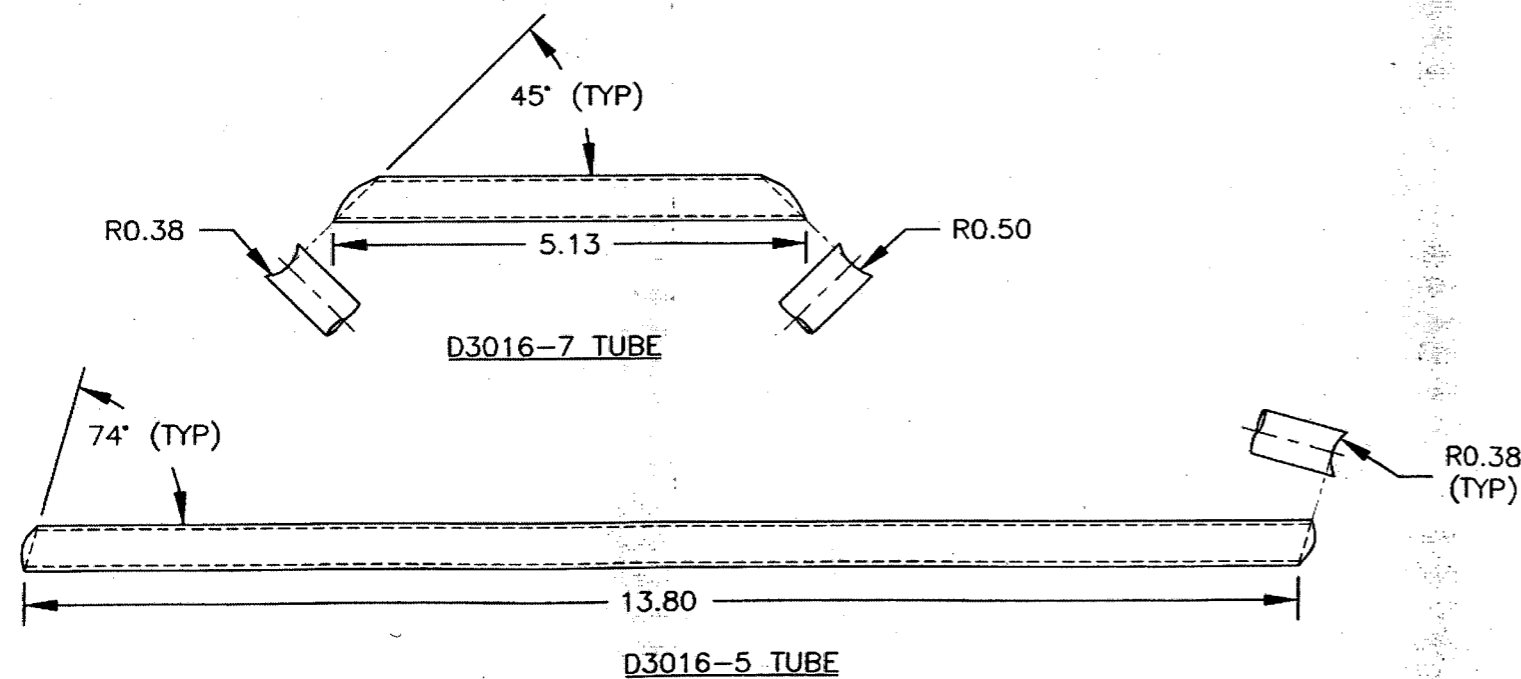
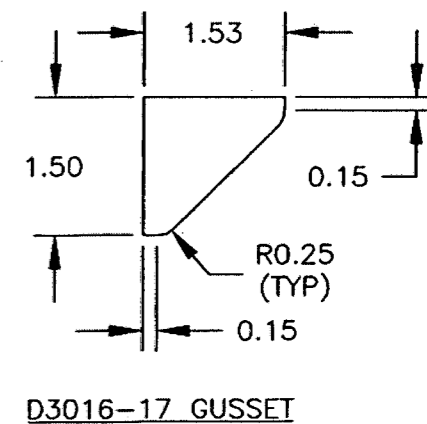
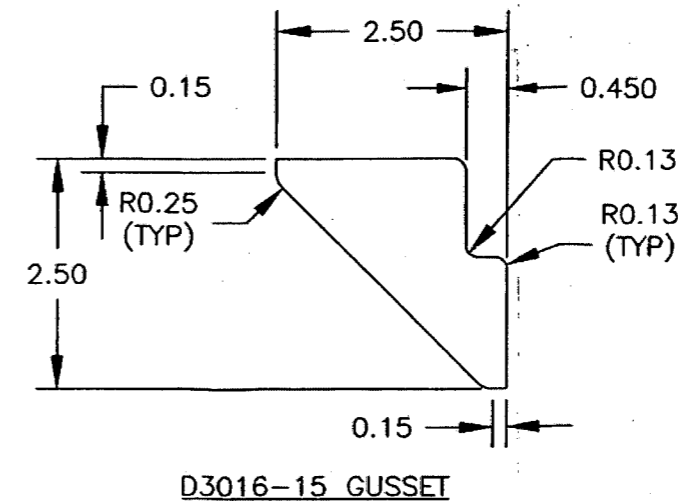
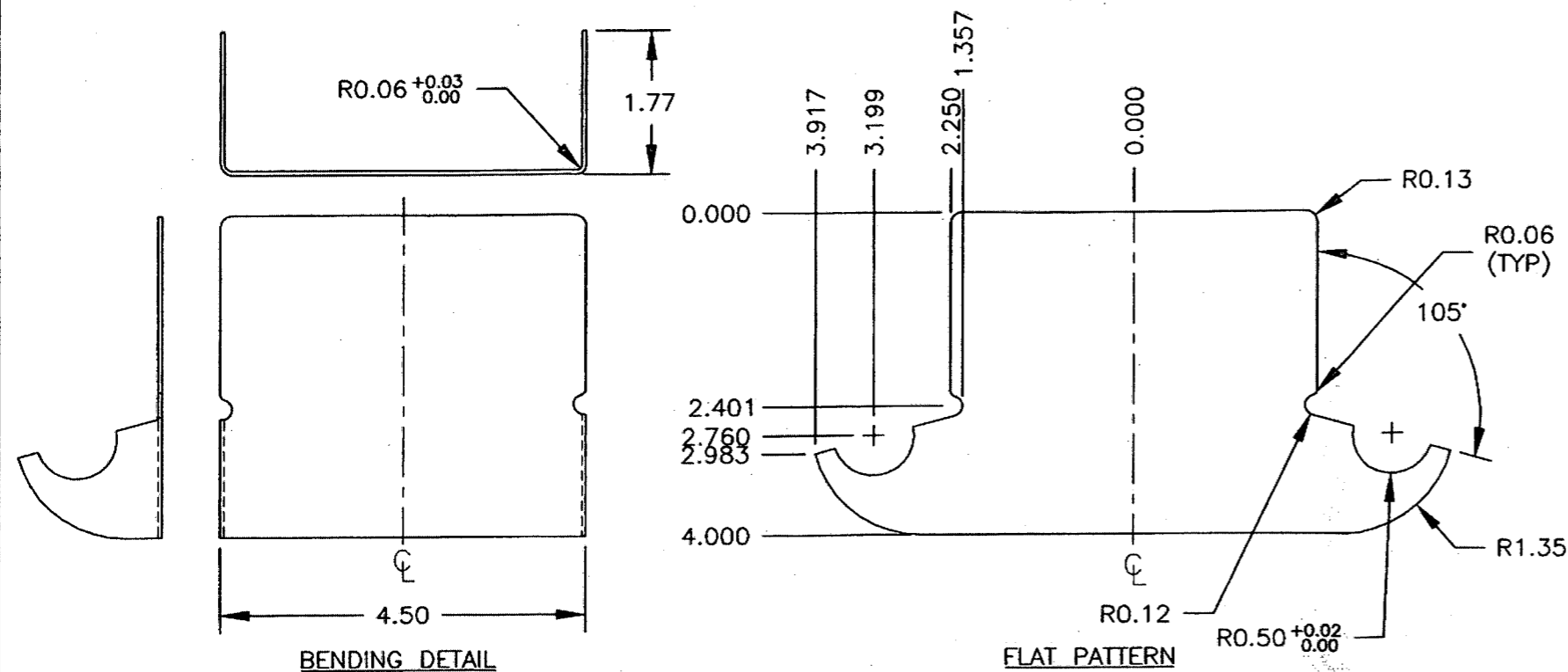
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42941

RELEASED
01.05.30

COPYRIGHT © 2001 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN UP	DRAWN BY UP	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3016	REV. A SHEET 2 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE 1:3



COPYRIGHT © 2001 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN
CP
CHECKED

DATE
01.05.18

DRAWN BY
CP
APPROVED
#

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3016

TITLE
SEAT FRAME ASSEMBLY

REV. A
SHEET 3 OF 3
SCALE
1:2

RELEASED
9.05.30